

Date: Monday, 1/14/2008 2:37:37 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	DOOR WEDGE
Job Number	36754		
Estimate Number	12111		
P.O. Number	:	Part Number	: D32003
This Issue	: 1/14/2008	S.O. No.	: D3200 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Type	: MACHINED PARTS
Previous Run	: 33945	Drawing Revision	: A
Written By	:	Material	:
Checked & Approved By	: <u>JL 08/02/05</u>	Due Date	: 2/5/2008
Comment	: Est Rev:A Removed from 9 Digit 06-01-25 JLM	Qty:	20 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MUHMWB10	UHMW 1" Black
	Comment: Qty.: 0.0158 sf(s)/Unit Total : 0.3150 sf(s)	
	UHMW 1" Black	
	Material: Black UHMW 0.95" or 1.00" thick	
	Use bearpaw scrap material	
	(MUHMWB10)	
	Identify for D3200-1	
	Batch: <u>M106161</u>	<u>JL 08/02/05</u>
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW	
	Cut blank: 1.000 X 1.800"	<u>JL 08/02/05</u>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1	
	1-Machine D3200-3 as per Folio FA337 and Dwg D3200	
	2-Deburr	<u>JL 08/02/06</u> (21)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>JL 08/02/06</u> (21)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOOR WEDGE

Job Number: 36754

Part Number: D32003

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8.F 08/02/06 (21)

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST76

AS 08/02/07 (21)

7.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Do 8/02/08

Job Completion



~ 2008/2/07 (21)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36754
Description: Door Wedge	Part Number:	D3200-3
Inspection Dwg: D3200	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L	Audited by:	S.P	Prototype Approval:	N/A
Date:	08/02/06	Date:	08/02/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D412-698-015	KJ/RF	[Signature]

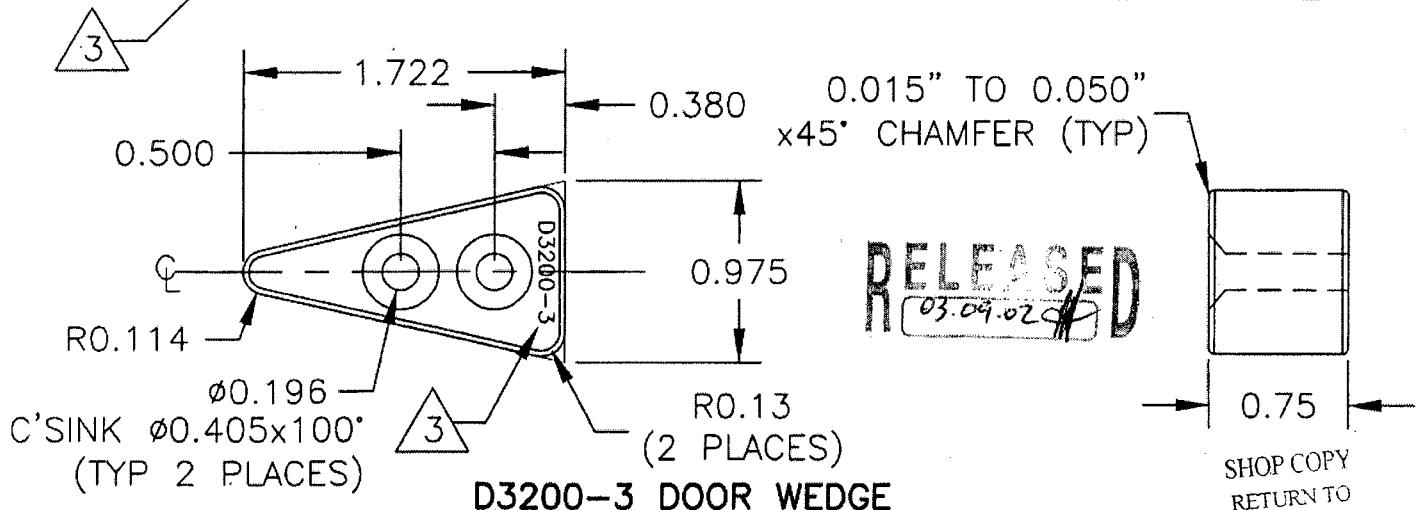
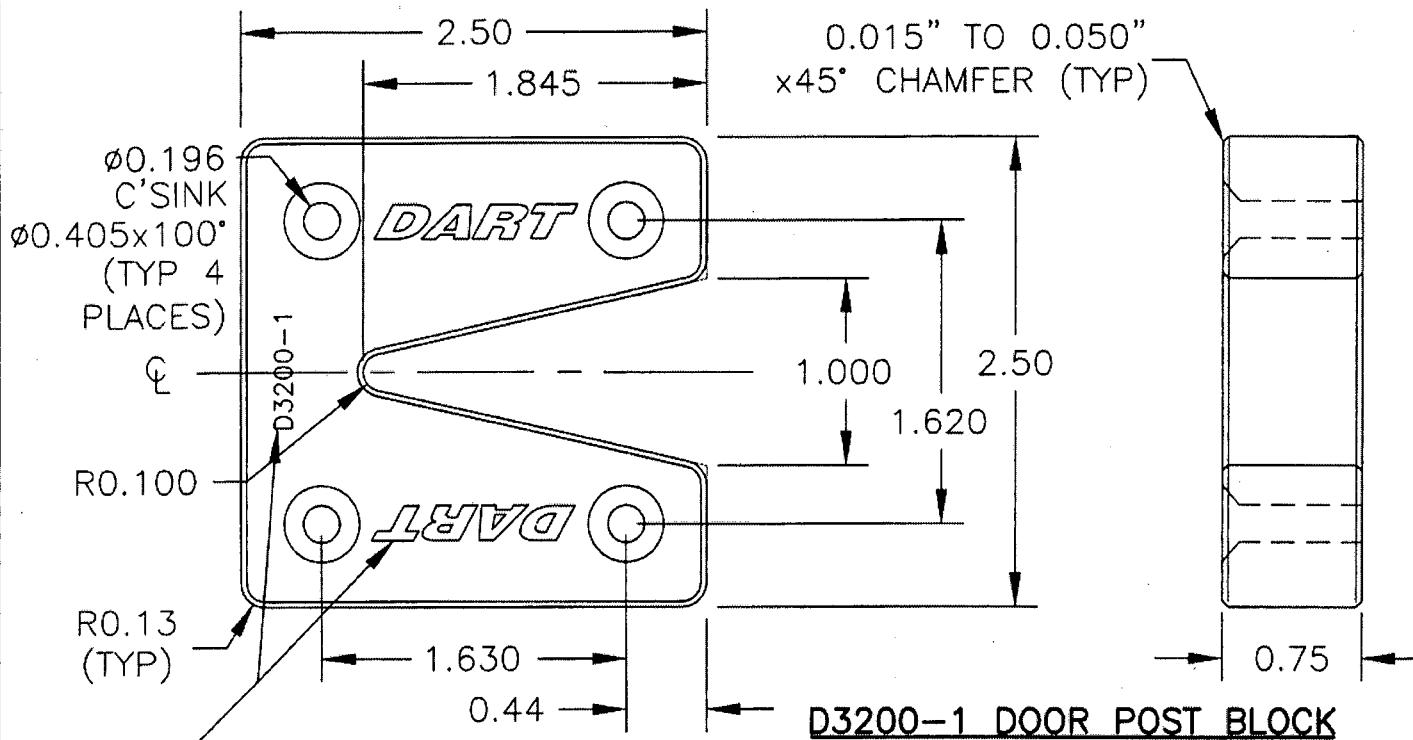
10

DART

COPY ISSUED TO

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3200
DATE		TITLE DOOR WEDGE
03.08.06		SCALE 1:1

A 03.08.06 NEW ISSUE

RELEASED
03.09.02**D3200-1/-3**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 36754

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